



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3310
Job Sheet 199514



Part No: 646.3310

Job Qty: 20 pcs
21 pcs

Part Name: LH Half - Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/27/19

Job Tracking No:

Due Date: 9/23/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12/11/17 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	HAAS 4 Axis	20 pcs	9/23/19		0.44	26.32	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 2	20 pcs	9/23/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

DAS
64

MM/B.A. 2019/09/29

DAS
64
9-800

130 QC 8	20 pcs	9/23/19	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
140 Outsource - 4 - Anodize	20 pcs	9/23/19		QC 8 - 68	
				QC 8 - 67	
150 Packaging 2-1 - Receive - B4B	20 pcs	9/23/19	0.00 0.00	QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				ATG001-VC	
				10	
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	

11/20/19/17

11/8 19/10/24

2019-10-25

NOV 28 2019

					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
155 QC 6	20 pcs	9/23/19	0.00	0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	20 pcs	9/23/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	

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DAS
JAN 08 2020 40
9-89

DAS
OCT 022 80
9-89
JAN 10 2020

					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	

190 QC 21 - SA	20 pcs	9/23/19	0.00	0.00	QC 21 - SA - 21 ✓	ack 022
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-20

Part Op 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB154 Blank 13.375
Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
140 - (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 44899 1- Black Anodize as per Dwg 646.3300
150 - (Receive & Inspect for Damage & Mat'l Certs)
155 - QC6- All purchased or subcontracted products
180 - (Identify as per dwg & Stock Location:) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T6S2.000X7.000	7075-T6S Sheet 2" Thick Plate X 7" Wide (Order In Billets - 13.375")	22.2800 ft (1.114 ea)	110-HAAS 4 Axis	5216177

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-HAAS 4 Axis	M7075T6S2.000X7.000	22	6	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	LH Half	7.296inches ± 0.005	7.301 7.291		
2	LH Half	3.767inches ± 0.005	3.772 3.762		
3	LH Half	0.457inches ± 0.005	0.462 0.452		
4	LH Half	0.313inches ± 0.005	0.318 0.308		
5	LH Half	0.710inches ± 0.005	0.715 0.705		
6	LH Half	6.469inches ± 0.005	6.474 6.464		
7	LH Half	10.116inches ± 0.005	10.121 10.111		
8	LH Half	10.309inches ± 0.005	10.314 10.304		
9	LH Half	0.177inches + 0.005 - 0.001	0.182 0.176	Diameter	
10	LH Half	0.209inches + 0.005 - 0.001	0.214 0.208	Diameter	
11	LH Half	0.250inches ± 0.005	0.255 0.245		
12	LH Half	1.250inches ± 0.005	1.255 1.245		
13	LH Half	0.125inches ± 0.005	0.130 0.120	Radius	
14	LH Half	3.513inches ± 0.005	3.518 3.508		
15	LH Half	8.375inches ± 0.005	8.380 8.370		
16	LH Half	0.250inches ± 0.005	0.255 0.245		
17	LH Half	8.100Degrees ± 0.500	8.600 7.600	Angle	
18	LH Half	11.689inches ± 0.005	11.694 11.684		
19	LH Half	11.250inches ± 0.005	11.255 11.245		
20	LH Half	0.200inches ± 0.005	0.205 0.195		
21	LH Half	45.000Degrees ± 0.000	45.000 45.000	Angle	

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Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)			
Description Work Order Deviation				Disposition			
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044899



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044899
PO Date: 10/25/19
Due Date: 11/11/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-15

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199515	646.3311	646.3300 Rev A	RH Half - Upper Cutter Assembly : Various STC's Outsource4 (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed X19	-	11/11/19	19 pcs	0 pcs	19 pcs	\$19.62/pcs	\$372.78
2	200991	646.3713	646.3700 Rev A	Gusset : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed X22	-	11/11/19	22 pcs	0 pcs	22 pcs	\$17.27/pcs	\$379.94
3	200993	646.3714	646.3700 Rev A	Gusset : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700 Rev. A	Firmed	-	11/11/19	20 pcs	0 pcs	20 pcs	\$17.27/pcs	\$345.40



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Canada

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PURCHASE ORDER

POHB044899



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	199514	646.3310	646.3300 Rev A	LH Half - Upper Cutter Assembly : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 1- Black Anodize as per Dwg 646.3300	Firmed <i>X21</i>	-	11/11/19	21 pcs	0 pcs	21 pcs	\$19.62/pcs	\$412.02

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DA
40
8-89

Grand Total: \$1,510.14

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guerin

Plex 11/15/19 10:01 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919033

Date: 27-Nov-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
19 ea	Part: 646.3311 RH Half Upper Cutter Assembly Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# 120908 Job: 26342 PO: POHB044899	Rev: A	atg
21 ea	Part: 646.3310 LH Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# 120908 Job: 26345 PO: POHB044899	Rev: A	atg
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: NOV 27 2019 Certified Signature: Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			

RECEIVED
NOV 27 2019
DART AEROSPACE LTD.



Fax: (613) 446-4556

Date: 27-Nov-19

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Fax: 613 632-1053

Made in Canada.